

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 40243

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg B67-43001

EP 08/07/24 (8)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/24 (8)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WTA*

08.01.28

8

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/08 (8)

Job Completion



08.08.01

Date: Friday, 11/4/2008 8:45:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 40243

Part Number: PB674300167

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5

PB6743001-147

INSPECT WORK TO CURRENT STEP



B 40024



Comment: INSPECT WORK TO CURRENT STEP

7.0

PB6743001149

Side Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Side Plate

B 40025

08-07-03

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: Weld assembly as per dwg B67-43001

08-07-03

9.0

QC9



VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/07 (X13)

10.0

QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/07 (X13)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

217/BK 08/07/16

(X13)

12.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/07/16 (X13)

(P10)

13.0

MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nutplate

M108601

M10856024x

08/07/17

14.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

RIVET

M105978

08/07/17

Date: Friday, 7/4/2008 8:45:43 AM
 User: Kim Johnston

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 90 DEGREE BLADE SUPPORT ASSY
 Job Number : 40243 -2
 Estimate Number : 13386
 P.O. Number :
 This Issue : 7/4/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run : 40024
 Part Number : PB674300167
 Drawing Number : B6743001 PAGE24
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 7/10/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : 1008 07.04
 Comment : Est Rev:A 08-06-19 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S090 6061-T6 .090 Sheet



Comment: Qty.: 0.624 sf(s)/Unit Total: 6.2412 sf(s)
 6061-T6 .090 Sheet
 batch: ~~B57224~~

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001-147
 Dwg Rev: B1
 Prog Rev: _____

2-Debur if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Form as per dwg B67-43001